

Date: Thursday, 22/01/2009 8:02:24 AM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD ADJUSTABLE BLADE SUPPORT ASSY
Job Number	: 45043		
Estimate Number	: 13435		
P.O. Number	:	Part Number	: PB674300111
This Issue	: 22/01/2009 S.O. No. :	Drawing Number	: B6743001 P.8
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 43061	Material	:
Written By	:	Due Date	: 28/01/2009 Qty: 9 Um: Each
Checked & Approved By	: <u>MF 09-01-22</u>		
Comment	: Est Rev:A 08-06-26 new issue DD verified by:ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001247	Inner Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Inner Tube

batch: 4x B43072, 5x 44965

MF 09-02-18

2.0	PB6743001249	Inner Tube Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Inner Tube Bushing

batch: B 23434, x2, B 41877 x 7mx

MF 09-02-18

3.0	PB6743001253	Gusset
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Gusset

batch: B 41492 x 9

MF 09-02-18

4.0	PB6743001254	Gusset
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

Gusset

batch: B 41493

MF 09-02-18

5.0	PB674300167	PB67-43001-67
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 9.0000 Each(s)

PB67-43001-67

batch: B 41214 x 2, B 40243 x 3, 45022 x 4

MF 09-02-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 45043

Part Number: PB674300111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

PL 09.02.23

9

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 09/02/23

(9)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/23

(TS)

9.0

MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)

HELICAL INSERT

17935

MF 09-02-13

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- install helicol insert as per dwg

PL 09.02.23

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/23

(TS)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

N/A

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M 18/44

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

PL 09/03/03

(9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 45043

Part Number: PB674300141

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

2:10

OVEN TEMPERATURE:

320°

FINISH TIME:

2:40

FL 09/03/03 (9)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-09 (9)

15.0

PB674300169

90 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)

90 Degree Cover Plate

batch: B40069 x3, 45762 x6

MF 09-03-05

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 9.0000 Each(s)

PB67-43001-83

batch: 45008

MF 09-03-05

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 72.0000 Each(s)

Screw

batch: M109031

MF 09-03-05

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 72.0000 Each(s)

WASHER

batch: M110704 x 28, 109053 x 44

MF 09-03-05

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

FL 09/03/09 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Part Number: PB674300111

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*090305 (9)*

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*ST.*

*Blade Fold section MF 09-03-10*

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/03/11 MF*

Job Completion



*MF 09-03-10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

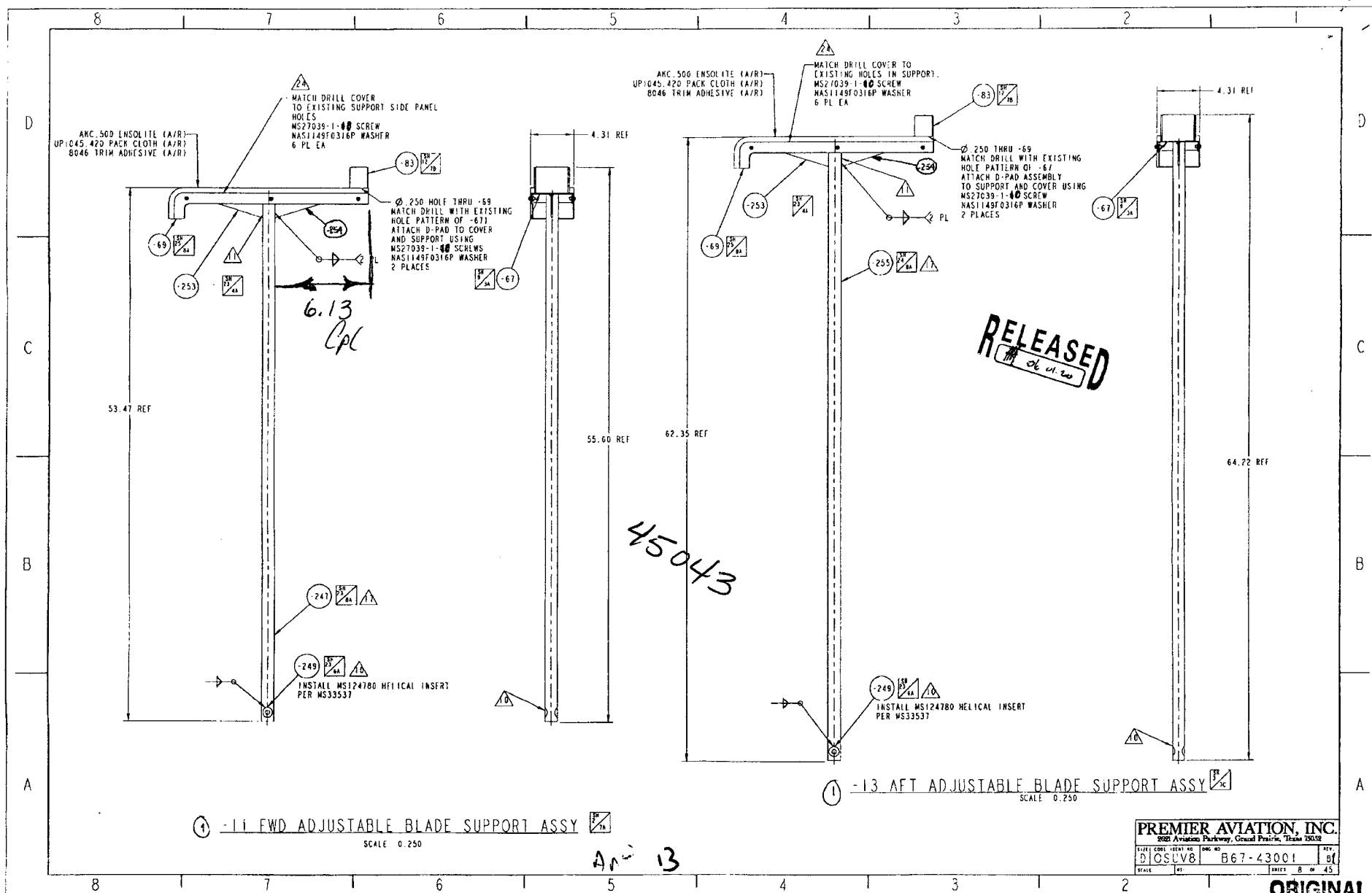
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





PREMIER AVIATION, INC.  
2025 Aviation Parkway, Grand Prairie, Texas 75052

SIZE	CODE	ISSUE NO	ENG NO	REV
DIGSUV8				
B67-43001			8	
SCALE	WT	SHEET B OF 45		

ORIGINAL